

Work Order ID 98165

March-08-13 9:53:46 AM

PF
98165

Page 1

Item ID: D2939-1**Accept****Revision ID:****Item Name:** Saddle LH In. 206**Start Date:** 3/08/13 **Start Qty:** 12.00***12*****Required Date:** 3/29/13 **Req'd Qty:** 12.00***12*****Reference:****Approvals:** *R* **Process Plan:****Date:** *13-03-8***Tooling:****Date:****Run****Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
-----------------	---------------------

D2939	Rev C
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100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

0.00

*FR 13/04/13**12 0**DA
3305*

HAAS CNC vertical machine #1

Memo Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

*FR 13/04/15**12 0*

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

120

QC1- Inspect dimensions to dimension sheet

0.00

*FR 13/04/13**12 0*

QC

*DA
33089*

Quality Control

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

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98165

Page 2

Item ID: D2939-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Saddle LH In. 206

Stop

NS2

Start Date: 3/08/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/29/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

04/13/15

12 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

0.00

12 26/13-4-16

PTO

155

Spray Painting per QSI005 4.2

0.00

155

SprayPaint

Spray Painting

Memo

0.00

PRIME B/17319
DELFLEET BLUE B/123253
DELFLEET CLEAR B/25035

START TIME:

FINISH TIME:

12

J.P. / J.W.
3-05-01

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Ant Date: 13/05/25QA Closed: U Date: 13/5/25

Work Order:	98165				DISPOSITION	AGAINST DEPARTMENT/PROCESS				
Part No.	D2939-1				Rework <input checked="" type="checkbox"/>	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No.	13-2465				Scrap <input type="checkbox"/>	Machining	Small Fab	Prod. Eng. Coor.	Quality	
					Use-as-is <input type="checkbox"/>	Thermoforming	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging	Other	
					Work Order Update <input type="checkbox"/>	Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				Fond on D4 x 12	DAS	Stain and report			DAS
Equip/Tooling				Plant the Part Does not		As per DAS + PQR			
Operator				ful covers in all areas	Q32005				
Material				+ the soon	13/05/13	Blue 125476	13-5-13	13-05-13	Q32012
Setup	13/05/13	15	12	PL. will look unbalanced	13/05/13	clear 125385			13/05/13
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend		Ovalized	Pressure/Forced
Centre Not Concentric to O/S	BOM/Route		Over/Under tolerance	Temperature/Cure
Cracks	Broken/Damaged		Part Incorrect	Weld
Crushed/Crimped	Burrs		Part Lost/Missing	Wrong Stock Pulled
Cuffs	Contamination		Part Moved	
Heat Treat	Countersink		Positioned Wrong	
Inspection Strip in Tube	Cut Too Short		Power Loss/Surge	Other
Ripples in Bend	Drill Holes			
Torque Waves in Extrusion	Drawing			
Turning Sequence	Finish			
Wave/Twist in Tube	Folio			

Work Order ID 98165

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Item ID: D2939-1

Accept

Revision ID:

Item Name: Saddle LH In. 206

Start Date: 3/08/13 Start Qty: 12.00

12

Required Date: 3/29/13 Req'd Qty: 12.00

12

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

165

165

QC

Quality Control

Operation
Description

QC14- Inspect Spray Paint

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS

05

8-89

13-05-15

170

Identify as per dwg & Stock Location: 5405A

0.00

170

Packaging

Packaging

Memo

0.00

12

13/5/16 50

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

13/5/2148

ML3 13-05-16

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____			Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	
NCR No. _____			Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	
			Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	
			Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear	General											
	Bending	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced					
	Centre Not Concentric to O/S	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure					
	Cracks	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld					
	Crushed/Crimped	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled					
	Cuffs	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>						
	Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>						
	Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other					
	Ripples in Bend	<input type="checkbox"/>	Offset	<input type="checkbox"/>		<input type="checkbox"/>						
	Torque Waves in Extrusion	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>						
	Turning Sequence	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>						
	Wave/Twist in Tube	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>						

Picklist Print

March-08-13 9:53:50 AM

Page 1

Work Order ID: 98165

98165
D2939-1

Parent Item: D2939-1

Parent Item Name: Saddle LH In. 206

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	2.0000	1	12		**	

D6101-001

Saddle Billet

Location	Loc Qty	Loc Code
MAT042	2	
94445	2	
97239		2
98456		1

FK 13/04/10

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

DART AEROSPACE LTD			Work Order:	98163
Description: 206 Saddle, Inboard, Left side			Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.105	.117	.115	.115		
B	0.100	0.140		.105	.114	.114	.114		
C	0.100	0.140		.125	.118	.119	.120		
D	0.210	0.230		.222	.222	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.238		
N	0.100	0.140		.115	.115	.114	.114		
O	0.540	0.560		.550	.550	.549	.550		
P	0.490	0.510		.497	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.741	2.741	2.741	2.741		
S	0.240	0.270		.256	.255	.255	.255		
T	0.100	0.180		.125	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.577	1.573	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	TSK /FK	Audited by:	✓
Date:	13/04/12	Date:	13/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM ✓	✓

DART AEROSPACE LTD	Work Order:	98165
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-3
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				5	6	7	8	9
A	0.100	0.140		.114	.115	.114	.114	.115
B	0.100	0.140		.114	.114	.114	.114	.114
C	0.100	0.140		.120	.120	.121	.120	.121
D	0.210	0.230		.222	.222	.222	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.238	.238	.238	.238	.238
N	0.100	0.140		.114	.113	.112	.112	.113
O	0.540	0.560		.549	.550	.550	.549	.550
P	0.490	0.510		.500	.499	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.741	2.741	2.741	2.741	2.742
S	0.240	0.270		.255	.255	.255	.255	.255
T	0.100	0.180		.130	.130	.130	.130	.130
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.259	1.259	1.258	1.258	1.259
Y	1.565	1.585		1.572	1.572	1.571	1.572	1.572
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: F.K.

Date: 13/04/13

Audited by: On

Date: 13/04/15

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	-	New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	BB

DART AEROSPACE LTD		Work Order:	981185
<i>Left</i>	<i>Right</i>	Description: 206 Saddle, Inboard, Right side	Part Number: D2939-1
Inspection Dwg: D2939	Rev: C	DSK:	Rev:

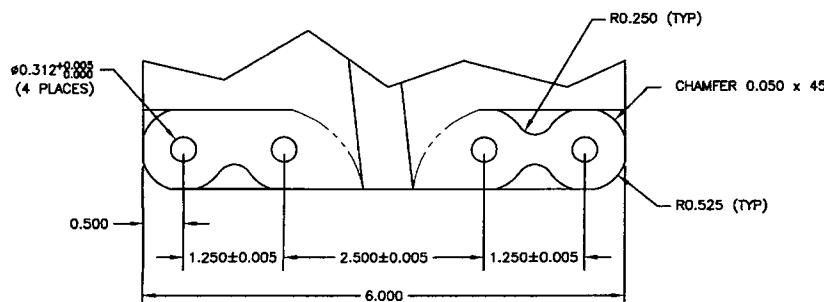
Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

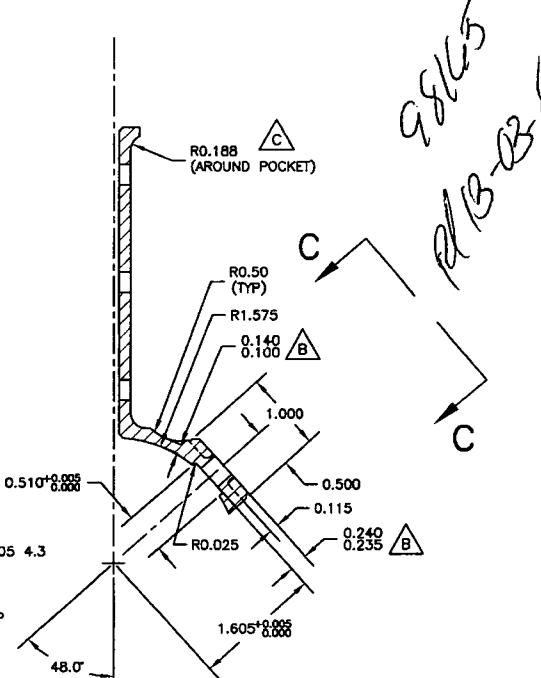
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				10	11	12	4	5
A	0.100	0.140		.113	.114	.114		
B	0.100	0.140		.113	.114	.114		
C	0.100	0.140		.119	.119	.119		
D	0.210	0.230		.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512		
I	1.572	1.582		1.574	1.574	1.574		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.238	.238	.238		
N	0.100	0.140		.115	.114	.115		
O	0.540	0.560		.548	.549	.549		
P	0.490	0.510		.498	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.741	2.741	2.741		
S	0.240	0.270		.254	.254	.254		
T	0.100	0.180		.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316		
X	1.250	1.270		1.261	1.260	1.260		
Y	1.565	1.585		1.574	1.573	1.573		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
Accept/Reject								
Measured by: <i>F.K.</i>				Date: 13/04/13				
Audited by: <i>CML</i>				Date: 13/04/13				
Prototype Approval: N/A				Date: N/A				

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD <i>JK</i>	<i>JK</i>



VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

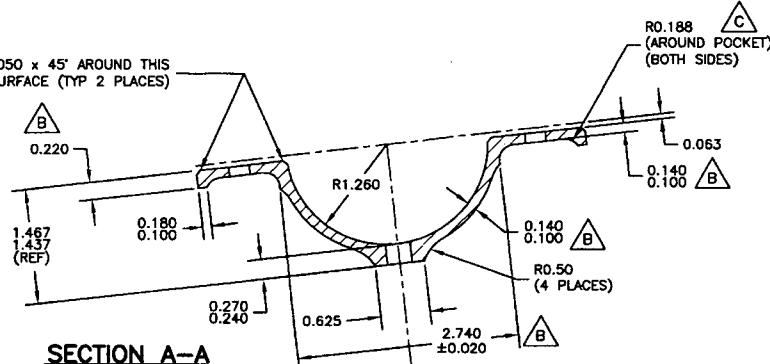


SECTION B-B

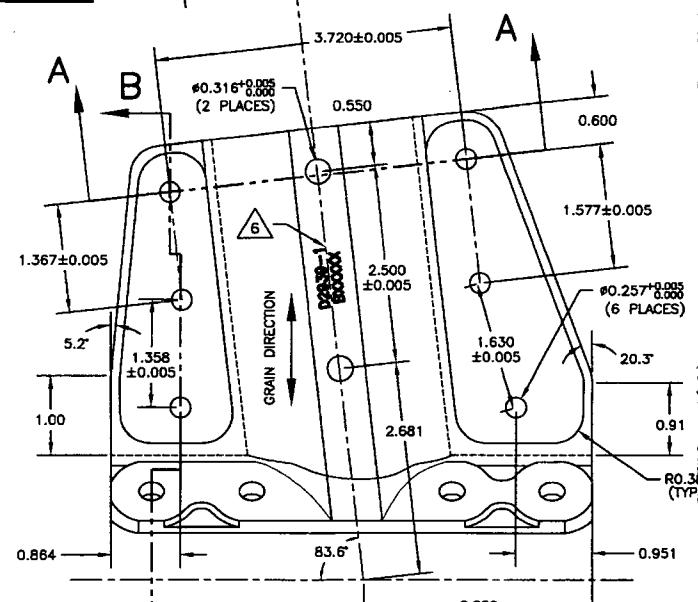
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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PH	DA	D2939	SHEET 1 OF 1
DATE	TITLE	SCALE	2:3
06.11.09	SADDLE INSIDE		

07.02.12